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pw AUG 29 2018

9 oct



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.3704

Job Sheet 182596



Part No: 647.3704

Job Qty: 1 ea

Part Name: 204,205,212,214 Cable Cutter System, High



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 10/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 647.3700 REV.A IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.26 as per ecr 14-214 DD VERF:JLM IPP REV:C AS PER REV NC3 15.03.18 JLM VERIFIED BY:DD IPP REV:D 18.01.19 AS PER DWG REV.A DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/9/18	10/9/18	0.00	0.00	Start Up Stores/Pkg-2		SEP 17 2018
110	Packaging	1 pcs	10/9/18	10/9/18	0.00	0.00	Packaging1-1		SEP 17 2018
120	QC	1 pcs	10/9/18	10/9/18	0.00	0.00	QC4		OCT 19 2018
125	DC	1 pcs	10/9/18	10/9/18	0.00	0.00	DC		OCT 19 2018
130	Packaging	1 pcs	10/9/18	10/9/18	0.00	0.00	Packaging3-1		OCT 19 2018
140	QC21-FG	1 Ea	10/9/18	10/9/18	0.00	0.00	QC21		OCT 19 2018

Part Op 125 - Photocopy bluefile & type labels per PPP 647.3704
Descriptions: 130 - Identify and pack for shipping as per PPP 647.3704

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	5075327
601.2045	RTV (LOCTITE 598)	1 Ea (1 ea)	90-Start up Operation	5068314
601.3073	Connector p/n 082-4440	1 Ea (1 ea)	90-Start up Operation	F163232
601.3083	Adhesive Rubber Seal	2 Ea (2 ea)	90-Start up Operation	5054871
647.3802	212 Upper Cutter Assembly	1 Ea (1 ea)	90-Start up Operation	F124717
647.3804	204,205,212,214,412 Lower Cutter Assembly High	1 Ea (1 ea)	90-Start up Operation	5000713
647.3903	Deflector Assembly	1 Ea (1 ea)	90-Start up Operation	5119351
647.4010	Wiper Deflector RH	1 Ea (1 ea)	90-Start up Operation	F158472
647.4011	Wiper Deflector LH	1 Ea (1 ea)	90-Start up Operation	5062598
647.4110	Doubler	1 Ea (1 ea)	90-Start up Operation	5004312
647.4111	Doubler	1 Ea (1 ea)	90-Start up Operation	F161210
647.4112	Clip	1 Ea (1 ea)	90-Start up Operation	F162469
647.4113	Clip	1 Ea (1 ea)	90-Start up Operation	F163487
647.4114	Shim	2 Ea (2 ea)	90-Start up Operation	5026930
647.4115	Shim	2 Ea (2 ea)	90-Start up Operation	5026933
647.4116	Shim	1 Ea (1 ea)	90-Start up Operation	5058999
647.4210	Bracket LH	1 Ea (1 ea)	90-Start up Operation	F161755
647.4211	Bracket RH	1 Ea (1 ea)	90-Start up Operation	F161784
647.4212	Plate	1 Ea (1 ea)	90-Start up Operation	F150884
647.4310	LH Lower Strut	1 Ea (1 ea)	90-Start up Operation	F158229
647.4311	RH Lower Strut	1 Ea (1 ea)	90-Start up Operation	F161672

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐												
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval										
Description Work Order Deviation		Container No: S110690 Part: 647.3704 Job No: 182596 Serial No/Batch: S110690 Revision: A Inspector: _____ Exp Date: _____ Instructions: FAA STC SR02289LA 17/02/07, TFA STC LQA RDIMS - 6068939 10/0		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____										
<table border="1" style="width:100%; border-collapse: collapse;"> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> </tr> <tr> <td style="width:30%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:30%;"> No Re-work Station ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:40%;"> Pressure/Torced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Clamp/Kick/Excessive Force ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> </tr> <tr> <td colspan="3" style="text-align: center;"> OTHER : _____ </td> </tr> </table>						Root Cause			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-work Station ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Torced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Clamp/Kick/Excessive Force ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	OTHER : _____		
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OTHER : _____														

647.4312	LH Upper Strut	1 Ea (1 ea)	90-Start up Operation	5162442
647.4313	RH Upper Strut	1 Ea (1 ea)	90-Start up Operation	5024532
647.4410	Rail	1 Ea (1 ea)	90-Start up Operation	5155358
AN3-11A	Bolt	8 Ea (8 ea)	90-Start up Operation	5078165
AN3-4A	Bolt	3 Ea (3 ea)	90-Start up Operation	5060063
AN3C10A	Bolt	2 Ea (2 ea)	90-Start up Operation	5019323
CCR264SS-3-03	Cherry Rivet	16 Ea (16 ea)	90-Start up Operation	5082912
CCR264SS3-04	Rivet	12 Ea (12 ea)	90-Start up Operation	5044217
CR3212-4-2	Cherry Rivet	11 Ea (11 ea)	90-Start up Operation	5000546
CR3212-4-3	Cherry Rivet	17 Ea (17 ea)	90-Start up Operation	5053949
CR3212-4-4	Cherry Rivet	7 Ea (7 ea)	90-Start up Operation	5045669
CR3213-4-2	Cherry Rivet	31 Ea (31 ea)	90-Start up Operation	5019424
CR3213-4-3	Rivet, Cherry	24 Ea (24 ea)	90-Start up Operation	5081869x6 5098033x18
CR3213-4-4	Rivet, Cherry	16 Ea (16 ea)	90-Start up Operation	5049830
CR3213-4-05	Rivet	28 Ea (28 ea)	90-Start up Operation	5019315
CR3213-4-8	Rivet	4 Ea (4 ea)	90-Start up Operation	FM136983-5
MS21042-08	Use Ms21042L08	18 Ea (18 ea)	90-Start up Operation	5044234
MS21042-3	Nut	79 Ea (79 ea)	90-Start up Operation	5027548x54 5084880x25
MS21047-3	Nut Plate	4 Ea (4 ea)	90-Start up Operation	5020620
MS21047L06	Nut Plate	6 Ea (6 ea)	90-Start up Operation	FM138408
MS21047L08	Nut Plate	6 Ea (6 ea)	90-Start up Operation	5016504
MS21071L3	Anchor Nut	4 pcs (4 ea)	90-Start up Operation	5055950
MS24694-C53	Screw	8 Ea (8 ea)	90-Start up Operation	FM137951-7
MS24694-S49	Screw	1 Ea (1 ea)	90-Start up Operation	FM129702
MS27039-08-08	Screw	16 Ea (16 ea)	90-Start up Operation	5053952
MS27039-08-11	Screw	2 Ea (2 ea)	90-Start up Operation	FM138336-10
MS27039-1-07	Screw	12 Ea (12 ea)	90-Start up Operation	5079112
MS27039-1-09	Screw	14 Ea (14 ea)	90-Start up Operation	5017101
MS27039-1-10	Screw	42 Ea (42 ea)	90-Start up Operation	5071834
NAS1149F0332P	Washer	157 Ea (157 ea)	90-Start up Operation	5103066
NAS1149FN832P	Washer	34 Ea (34 ea)	90-Start up Operation	5100408

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	16	0
	601.2045	1	22	0
	601.3073	1	3	0
	601.3083	1	3	0
	647.3802	1	2	0
	647.3804	1	1	0
	647.3903	1	0	0
	647.4010	1	10	0
	647.4011	1	8	0
	647.4110	1	4	0
	647.4111	1	3	0
	647.4112	1	12	0
	647.4113	1	6	0
	647.4114	2	9	0
	647.4115	2	9	0
	647.4116	1	17	0
	647.4210	1	9	0
	647.4211	1	9	0
	647.4212	1	4	0
	647.4310	1	12	0
	647.4311	1	2	0
	647.4312	1	5	0
	647.4313	1	5	0
	647.4410	1	4	0
	AN3-11A	8	240	0
	AN3-4A	3	161	0
	AN3C10A	2	17	0
	CCR264SS-3-03	16	672	0
	CCR264SS3-04	12	70	0
	CR3212-4-2	11	119	0
	CR3212-4-3	17	141	0
	CR3212-4-4	7	290	0
	CR3213-4-2	31	137	0

506182596

005447

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

CR3213-4-3	24	336	0
CR3213-4-4	16	719	0
CR3213-4-5	28	180	0
CR3213-4-8	4	124	0
MS21042-08	18	1	0
MS21042-3	79	84	0
MS21047-3	4	544	0
MS21047L06	6	23	0
MS21047L08	6	15	0
MS21071L3	4	57	0
MS24694-C53	8	51	0
MS24694-S49	1	155	0
MS27039-08-08	16	80	0
MS27039-08-11	2	1,295	0
MS27039-1-07	12	49	0
MS27039-1-09	14	124	0
MS27039-1-10	42	332	0
NAS1149F0332P	157	1,715	0
NAS1149FN832P	34	2,302	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



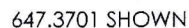
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

6 VENDOR: MCMaster-CARR
VENDOR P/N: 86715K27
60A DUROMETER



	REF	REF	REF	56	647.5701				
A/R	A/R	A/R	A/R	55	601.2045	RTV		LOCITITE 598	
A/R	A/R	A/R	A/R	54	601.1012	SEALANT		PR-142S CLASS II	
2	2	2	2	53	601.3083	ADHESIVE RUBBER SEAL		MIL-R-3085	
4	4	4	4	52	601.2957	NUTPLATE		MS21071-3	
4	4	4	4	51	600.0795	NUTPLATE		MS21047-3	
6	6	6	6	50	601.3066	NUTPLATE		MS21047L06	
6	6	6		49	601.3065			MS21047L06	
18	18	18	18	48	601.2973	LOCKNUT		MS21042-08	
79	79	79	79	47	601.2943	LOCKNUT		MS21042-3	
4	4	4	4	46	601.2364	CHEERRY RIVET		CR3213-4-8	
28	28	42	42	45	601.1183	CHEERRY RIVET		CR3213-4-5	
16	16	19	19	44	601.1915	CHEERRY RIVET		CR3213-4-4	
24	24	32	32	43	601.0790	CHEERRY RIVET		CR3213-4-3	
3704	3703	3702	3701	FIND	PART #	DESCRIPTION		MAT'L	SPEC.

[illegible]

QTY	ORIGINAL DATE JAN-24-79	30-29-69	PARTS LIST	
NEXT ASSY (S)	DRAWN BY J. JACKSON	CHECKED D. BARKER	 3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081-8347 (760) 724-5300 AEROSPACE AERIAL INDUSTRIES, INC. (aka DART Aerospace)	
	DRAFT APPROVAL 9-25-77 D. BRAVO			
	CONTRACT NO.			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .001 ANGLES ± .5°			
			SEE B	CAGE CODE 07M26 SCALE NONE
			DWG. NO. 647.3700	REV. A
			SHEET	1 OF 5